

Date: Wednesday, 23/07/2008 11:28:36 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LID PRO ARM ASSEMBLY (SHORT)			
Job Number	: 40718			Part Number	: D2332041		
Estimate Number	: 10258			Drawing Number	: D2332		
P.O. Number	:			Project Number	: N/A		
This Issue	: 23/07/2008	S.O. No. :		Drawing Revision	: C		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type :	SMALL /MED FAB	Due Date	: 30/07/2008		
Previous Run	: 39332			Qty:	27 Um: Each		
Written By	:						
Checked & Approved By	: JLD 08-7-23						
Comment	: Est: B 02.08.12 Re-format; Incorporated D2332-13/11-7-5KJ/ RF Est Rev:C 08-06-02 add comment DD verified by:EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	Barcode
1.0	M304TR1000WO49	304 RD Tube 1.00 x .049W	
		Comment: Qty.: 0.4331 f(s)/Unit Total : 11.6944 f(s) Material: 1.000" OD x 0.049" wall SS-Tube (Seamless)	
		<i>1108756</i>	<i>E808/08/11</i>
2.0	M304R250	304 SS Round bar .250	
		Comment: Qty.: 0.1092 f(s)/Unit Total : 2.9484 f(s) Material: Ø0.250" 304SS Rod	
		<i>1107389</i>	<i>E808/08/11</i>
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE	
		Comment: SMALL & MEDIUM FAB RESOURCE 1	
4.0	M304TR0500W035	304 RD Tube .500 x .035W	
		<i>1108215</i> <i>1107166</i> <i>1107967</i> <i>1107403</i>	<i>E808/08/11</i>
		Comment: Qty.: 1.2502 f(s)/Unit Total : 33.7564 f(s) 304 RD Tube .500 x .035W	
		<i>1107389</i>	<i>S8 58 b8 11</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Punch or form to length as per Dwg D2332 (D2332-11) using DT8012

(Note: Make (2) D2332-11 Prop Arms per assembly.)

SB 08/08/12

28

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill hole in D2332-11 as per Dwg D2332 using Drill Jig DT8459. (Drill 1 per assembly)

2-ensure no foreign objects inside fo tube and deburr

7.0 QC5 INSPECT WORK TO CURRENT STEP



28

Comment: INSPECT WORK TO CURRENT STEP

8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld D2332-11 and D2332-5 as per Dwg D2332 using Welding Jig DT8298. (Weld 1 per assembly)

***** insure nothing is inside of tube before welding*****

A/R SS Rod Batch: M107057

*****brush weld right after welding, to take color off *****

L2 8-8-19

9.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-08-20 28

10.0 QC5 INSPECT WORK TO CURRENT STEP



Pt

Comment: INSPECT WORK TO CURRENT STEP

6 08/08/20 26

11.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Assemble as per Dwg D2332

JF 08/08/21 25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2332-041 PAR #: N/A Fault Category: Prod/Lay Fab welding. NCR: Yes No DQA: Date: 08.08.22
 D350-607 QA: N/C Closed: Date: 08/08/20

NCR: 40718		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/08/20	100	During inspection 2 Part(s) were found with forging parts inside. i.e. Parts were not cleaned 100% inside.	<input checked="" type="checkbox"/> Resair	SCRAP and Destroy no Replace QTY <input checked="" type="checkbox"/> D2332-13	LZ 08-08-20	S 08/08/20	<input checked="" type="checkbox"/> Resair	<input checked="" type="checkbox"/> 08/08/20
		100% inside						

NOTE: Date & initial all entries

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Process Sheet

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Drawing Name: LID PRO ARM ASSEMBLY (SHORT)

Job Number: 40718

Part Number: D2332041

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 AN44A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 27.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN4-4A	Bolt	<u>1106918</u>



13.0 AN960JD416L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 81.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
3	AN960JD416L	Washer	<u>1108583</u>



14.0 MS21042L4

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 27.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS21042L4	Nut (or -4)	<u>1107499</u>



15.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 08/08/01

x26

16.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST203

C 08/08/21

x26

17.0 QC21

FINAL INSPECTION/W/O RELEASE



08/08/21

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Mf 08-08-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

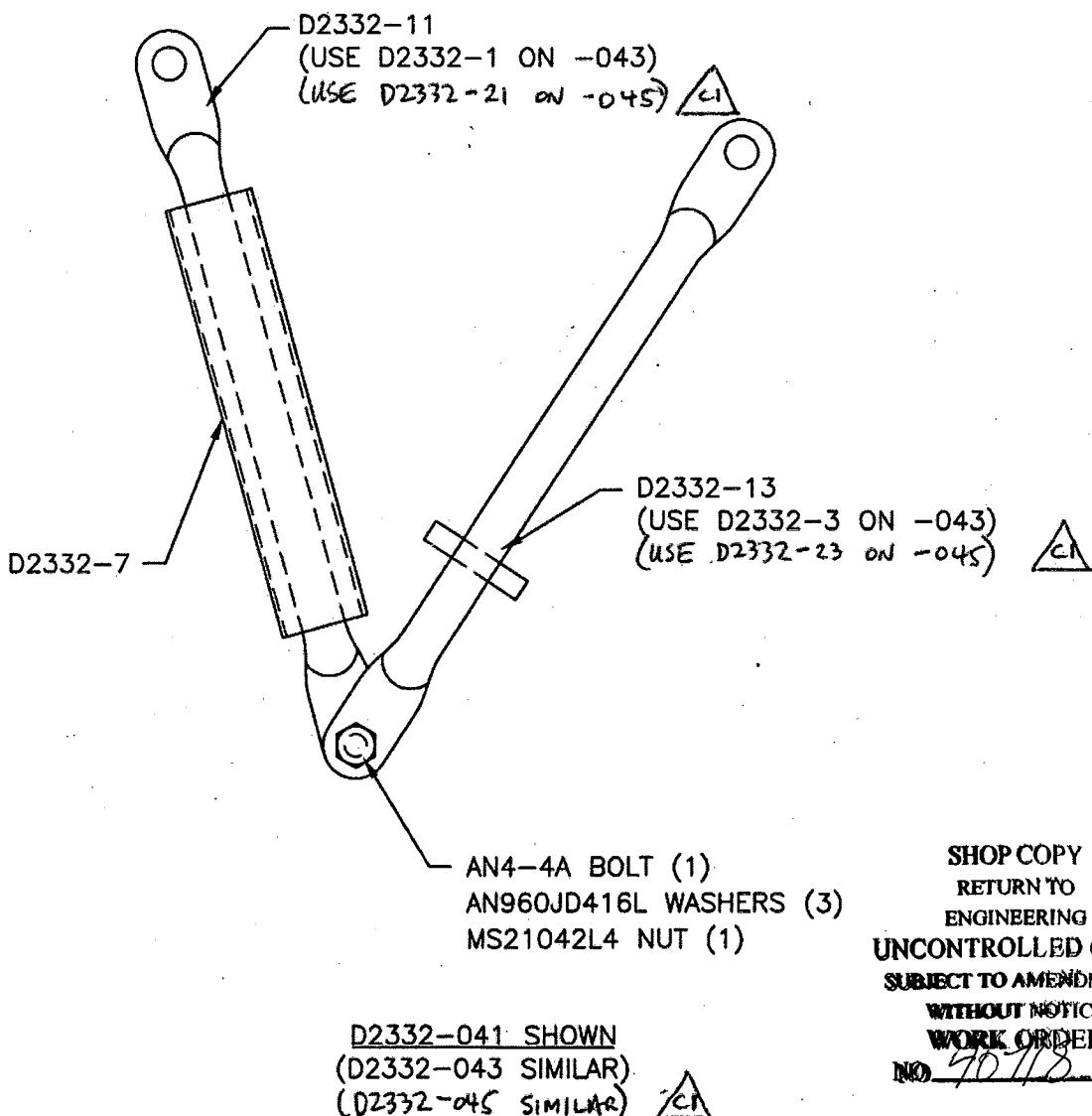
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D2332	SHEET 1 OF 2
DATE		TITLE	SCALE
03.07.03		LOD PROP ASSEMBLY	NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
C1	03.08.06	ADD -045 prop (7.25" LONG)	

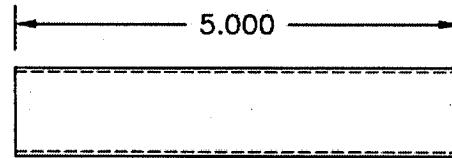
RELEASED
 03.07.04


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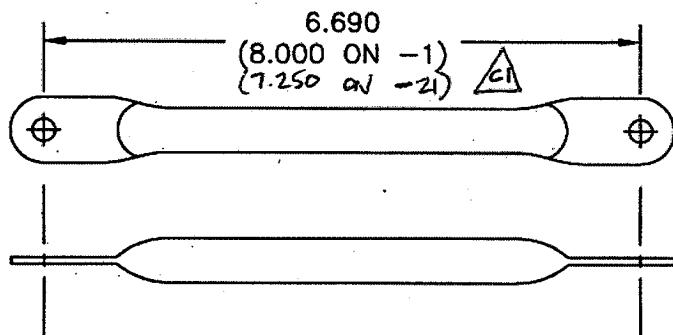
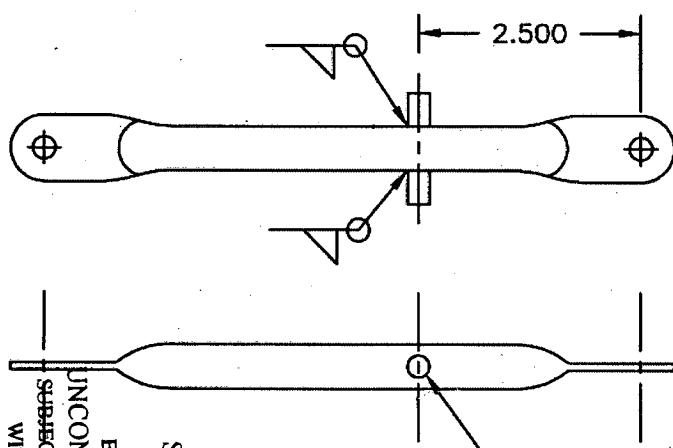
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DRAFTS

DESIGN	DRAWN BY	DART AEROSPACE LTD
		HAWKESBURY, ONTARIO, CANADA
DATE	TITLE	SCALE
03.07.03	LID PROP ASSEMBLY	1:12
C	MATERIAL - 0.5 OD SS TUBE (D2332-1/-11) M304TR0.500W.035 0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250 1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049	MADE - 0.5" Prop 6.69" long (17cm) MADE - 0.25" Prop 8.0" long (20cm)
C1	ADD - 0.45 Prop (7.25" long)	



D2332-7 LOCKING COLLAR

D2332-11 PROP
(D2332-1 SIMILAR)

DRILL 1/4 HOLE FOR D2332-5

SHOP COPY /F D2332-11 & D2332-5
RETURN TO ENGINEERING CORP
UNCONTROLLED SUBJECT TO AMENDMENT
WORK ORDER NO. 4078

NOTES:

1. MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
2. TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

RELEASED

03.07.04